

WE CLAIM:

1. Method for the production of extra-wide veneers (and from them the production of endless laminated wood boards by gluing and pressing a chain of veneers combined from these extra-wide veneers one over the other and behind one another in a plurality of layers,) characterized in that the oncoming veneers with a producible width b and grain running transversely are combined one behind the other into a chain of veneers, stitched together at their abutting edges or adhered together with adhesive tape, and laminated wood boards with a given extra-width (B) are cut off in the direction of the grain such that the seams or abutting edges of the laminated wood boards are distributed irregularly over the width of a laminated wood board, not in line with one another.

2. Method of claim 1, characterized in that the joining together of the veneers to form a chain of veneers is performed with untrimmed abutting edges.

3. Method of claim 1, characterized in that the joining of the veneers to form a chain of veneers for the covering layers of a laminated wood board is performed with trimmed abutting edges.

4. Apparatus for the practice of the method of claim 1, comprising a veneer supply station, a vacuum conveyor belt for lifting off and advancing the veneers on a supply stack that can be raised and lowered, and apparatus for further transport onto a feeding belt of an LVL production line, characterized in that in a continuously operating manner veneers (1) with their grain (c) and their producible width (b) oriented across the direction of feed (F) are lifted from the vacuum conveyor belt onto a double-belt conveyor (6), the apparatus following the double belt conveyor (6) having a sewing machine (5) for sewing together the oncoming junctions (d) between two veneers (1) and the chain of veneers (14) thus formed can be transferred to a second double conveyor belt apparatus (15), the chain of veneers (14) can be severed by a cutting apparatus (7) to a given length equal to the corresponding width (B) of a extra-wide veneer board (10), and that the thus severed extra-wide veneer board (10) can be laid by means of a second vacuum conveyor belt (8) onto a feeding belt (13) running at right angles thereto with their grain(c) now running in the direction of feed of the LVL production machine.

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5. Apparatus for the practice of the method of claim 1, comprising a veneer supply station, a vacuum conveyor belt for lifting and carrying the veneers which can be raised and lowered on a supply stack, and apparatus for depositing onto a supply stack, characterized in that, in a continuously operating manner, veneers (1) with their grain (c) and their producible width (b) oriented across the direction of feed (F) are lifted from the vacuum conveyor belt (4) for transfer to a double conveyor belt (6), the apparatus has following the double belt conveyor (6) a sewing machine (5) for sewing together the oncoming abutting edges (d) of two veneers, and the chain of veneers (14) thus formed can be transferred to a second double belt conveyor (15), the chain of veneers (14) can be severed by means of a cutting apparatus (7) to a given length equal to the corresponding width (B) of an extra-wide laminated wood board (10), and that the extra-wide laminated wood boards (10) thus severed can be deposited onto a transport pallet to form a supply stack.

6. Apparatus according to claim 5, characterized in that the cutting apparatus (7) is equipped with a single-edged knife.

7. Method for producing extra-wide veneer boards comprising the steps of:

- a) combining oncoming veneers with a producible width b and grain running transversely one behind the other into a continuous chain of veneers;
- b) fastening together abutting edges of the oncoming veneers to form seams; and
- c) repetitively cutting the continuous veneer chain in a direction of the grain to form extra-wide veneer boards with a given extra-width (B).

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A2

8. Method according to claim 7, further comprising the step of:

- d) gluing and pressing a chain of veneers combined from the extra-wide veneer boards one over the other and behind one another in a plurality of layers to form an endless laminated wood board, the extra-wide boards being layered such that the seams are not in line with one another.

9. Method according to claim 8, wherein step a is performed with oncoming veneers having trimmed abutting edges for the extra-wide veneer boards that form top and bottom cover layers of the endless laminated wood board.

10. Method according to claim 7, wherein the fastening step includes stitching the veneers together.

11. Method according to claim 7, wherein the fastening step includes adhering the veneers together with adhesive tape.

12. Method according to claim 7, wherein the extra wide veneer boards are cut off in step c such that the seams are distributed irregularly over the width of the extra-wide veneer board.

13. Apparatus for producing extra-wide veneer boards, comprising:
a conveyor belt system adapted to convey oncoming veneers with a producible width b one behind the other to form a veneer chain, the conveyor belt moving in a direction transverse to a grain of the veneers;
a fastening device positioned on the conveyor belt system and adapted to fasten together abutting edges of the oncoming veneers of the veneer chain to form seams;
and
a cutting device positioned on the conveyor belt downstream from the fastening device and adapted to cut the veneer chain in a direction of the grain to form extra-wide veneer boards with a given extra-width (B).

14. The apparatus claimed in claim 13, wherein the cutting device is further adapted to cut off the extra wide veneer boards such that the seams are distributed irregularly over the width of the extra-wide veneer board.

15. The apparatus as claimed in claim 13, wherein the conveyor belt system comprises a first double conveyor belt on an upstream side of the fastening device and a second double conveyor belt positioned on a downstream side of the fastening device.

16. The apparatus as claimed in claim 13, further comprising:
a veneer supply station adapted to raise and lower a veneer supply stack;
a vacuum conveyor belt adapted to lift veneers from the veneer supply stack onto an upstream end of the conveyor belt system.

17. The apparatus as claimed in claim 13, further comprising a feeder belt of an LVL production line positioned at a downstream end of the conveyor belt system and running at a right angle to the conveyor belt system.

18. The apparatus as claimed in claim 17, further comprising a vacuum conveyor belt adapted to convey the extra wide veneer boards from the downstream end of the conveyor belt system to the feeder belt of the LVL production line such that the grain runs in the same direction as the feeding belt.

19. The apparatus as claimed in claim 13, further comprising:
a feeder belt positioned at a downstream end of the conveyor belt system and running at a right angle to the conveyor belt system;

a lifting platform positioned at a downstream end of the feeder belt such that extra wide veneer boards are stacked on the lifting platform after being conveyed to the lifting platform from the feeder belt.

20. The apparatus as claimed in claim 19, further comprising a vacuum conveyor belt adapted to convey the extra wide veneer boards from the downstream end of the conveyor belt system to the feeding belt such that the grain runs in the same direction as the feeding belt.

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A4